Quality Control

### Work Order ID 92038

October-19-12 2:43:59 PM

\*92**@**38\*

Page 1

Item ID: 646.9501 \*N900040100\* Accept Setup Start **Revision ID:** Item Name: 206 Cable Cutter, High 19/10/2012 Start Oty: 1.00 \*1\* **Start Date: Cust Item ID: Customer:** Reference: Run Process Plan: MU5 Date: 12-10-19 Tooling: Approvals: Date: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Qty Qty Code Number Stamp **Draw Nbr Revision Nbr** 646.9500 N/C DAS 27 100 0.00 9-89 DOCUMENT CONTROL \*100\* DC Memo Document Control Photocopy bluefile & type labels per PPP 646.9501 110 Pick Kit 0.00 \*110\* Packaging 0.00 Memo Packaging DAS 27 120 QC4-100% Inspect kits for completeness 0.00 9-89 \*120\* OC 0.00 Memo

\_Date: \_\_\_\_\_\_ **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: DISPOSITION **AGAINST DEPARTMENT/PROCESS** Work Order: Engineering Skid-tube Crosstube Water Jet Rework Part No. Prod. Eng. Coor. Machining Small Fab Quality Scrap Rec/Store/Packaging Other Use-as-is Thermoforming Finishing NCR No. Composite Supplier Work Order Update Large Fab Action Sign & Description of work order update Initial Root or Non-conformance Chief Eng Description Date Verification QC Inspector Cause Date Step Qty Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Hardware Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Broken/Damaged Part Incorrect Weld Inspection Incomplete Cracks Wrong Stock Pulled Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Maintenance Part Moved Contamination Mislabeled Positioned Wrong **Heat Treat** Countersink Other Power Loss/Surge Misread Inspection Strip in Tube Cut Too Short Offset Drill Holes Ripples in Bend

Out of Calibration

Out of Sequence

**Outside Dimensions** 

DQA:

**Turning Sequence** 

Wave/Twist in Tube

**Torque Waves in Extrusion** 

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

QC

Quality Control

Page 2 October-19-12 2:43:59 PM Item ID: 646,9501 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: 206 Cable Cutter, High **Start Date:** 19/10/2012 **Start Qty:** 1.00 Cust Item ID: **Required Date:** 02/11/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Approvals: Tooling: Date: Stop QC: \_\_\_\_\_ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 130 0.00 \*130\* Packaging Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPP 646.9501 Location: ( 909) 140 1 pl/3-10-3 mx 7-02 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

NCR:	Yes	/ No				WORK ORDER NON-	COI	<b>NFORM</b>	MANCE / UP	DATE					
											QA Closed:	Date	2:		
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No					·	Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root					Descri	ption of work order update	T	Initial	Act	tion	Sign &				
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							AUL	T CATE	GORY						
Landi		ear Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	Crimped. t 1 Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misreac Offset	ion Incomplete ions Incomplete/U enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		

Out of Sequence

Outside Dimensions

DQA: \_\_\_\_\_Date: \_\_\_\_

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:03 PM

Work Order ID: 92038

\*92038\*

Parent Item:

646.9501

\*646 9501\*

Parent Item Name: 206 Cable Cutter, High

Start Date: 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IF	PP REV:A 12.08	28 NEW ISSUE	DD V	VERF:JLM					- •		•		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9601 <b>************************************</b>	*) SM	Manufactured	No			110	Each	0.0000	** _	7/2	83 2	В	SP
646.9602 <b>*646.9602</b> Lower Cutter Assembly, High	* Shif	Manufactured	No			110	Each	0.0000	**	1 9128	18 g B	<b>)</b>	Sp
646.9810 <b>*646_9810</b> Deflector	, _, /	Manufactured	No			110	Each	0.0000	**	1	145 g	ø'	FP_
647.0210 [*647-094-0	- 0	Manufactured	No			110	Each	0.0000	**	9144	0 23		F
647.0110 * <b>647</b>	5 mD	Manufactured	No			110	Each	0.0000	**	8970	3 78		ÎF
*647.0310 *647.03.163 Channel	5Mr	Manufactured	No			110	Each	0.0000	** 9	2 30 <b>50</b> 2	o gb	·	80
646.9910 *646-9910* Strut	* Shr	Manufactured	No			110	Each	0.0000	**	4 9318	- 9 g/	,	82
647.0112  *64.7 0112  Strut Bräcket	SHI	Manufactured	No			110	Each	0.0000	** 5X 3 X	8 9 <i>[7<b>9</b>]</i> 9197:	1 / Jh	13-00	7-03
				*	*			٠		•		<u> </u>	Ž):

										DQA:	Date	::	•
NCR: Y	es / No				WORK ORDER NON-0	CONF	FORN	MANCE / UPDATE		QA Closed:	Date	:	
Work Orde	er:				DISPOSITION			AGAINS	T DE	PARTMENT/	PROCESS		
	Part No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			ngineering Quality Other
Root				Descri	l ption of work order update	lni	tial	Action		Sign &			
Cause	Date	Step	Qty	C	or Non-conformance	Chie	f Eng	Description		Date	Verification		QC inspector
Doc/Data													
Equip/Tooling													:
Operator												-1	
Material							:				.'		7
Setup	_												
Other													
Process '	_							,					
Supplier Training	<del>-</del>									3		.	
Unapproved												ĺ	
Chappioved	<u> </u>	<u> </u>	1 1		·	AULT	CATE	GORY			,	<u> </u>	
Landir	ng Gear				General	7.021	0,112					2	
•	Bending				Bend	П	irain			Ovalized	Γ	Pre	ssure/Forced
Ì	Centre No	ot Concer	ntric to O/S	. $lacksquare$	BOM/Route	ΗН	ardwa	re		Over/Under	tolerance	Ten	nperature/Cure
	Cracks				Broken/Damaged	In	specti	on Incomplete		Part Incorred	st i milija i 🗍	We	ld ·
	Crushed/	Crimped.			Burrs	In	nstructi	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wro	ong Stock Pulled
	Cuffs				Contamination	$\square$	/lainte	nance		Part Moved	_		
	Heat Treat Countersink				1islabe	led		Positioned V	Vrong _	_			
	Inspection Strip in Tube Cut Too Short		Шм	1isread			Power Loss/	Surge	Oth	er			
	Ripples in Bend Drill Holes			$\vdash$	ffset								
	Torque W	aves in E	extrusion		Drawing		ut of C	Calibration					
	Turning S				Finish	-		equence					· .
	Wave/Tw	ist in Tub	e		Folio		utside	Dimensions					

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October-19-12 2:44:03 PM

Work Order ID: 92038	•	*92038*					
<b>Parent Item:</b> 646.9501		*646 9501*					
Parent Item Name: 206 Cable Cutter	, High	()() ()()()			St	tart Date: 19/10/2012	<b>Required Date:</b> 02/11/2012
					S	Start Oty:-1.00	Required Qty: 1.00
647.0113	Manufactured	No	110	Each	0.0000	$L_2$ .	
*647 0113*) Skrut Doubler	B					** 126249	JB _500
647.0111	Manufactured	No	110	Each	0.0000	<u> </u>	
*647 0111* Sh						** 8970	63 JB 8P
647.0116	Manufactured	No	110	Each	0.0000	$\frac{2}{2}$ 2	
*647 0116*  Doubler DAS						** 89	699 70 8
647.0410 27	Manufactured	No	110	Each	0.0000		- BD
*647-0410* 9-89			·			** 9049	1 79 8
647.0114 DAS	Manufactured	No .	110	Each	0.0000	1	- 0
*647_0114*9-89						** 1262	49 20
647.0115 DAS	Manufactured	No	110	Each	0.0000		<u>~</u>
*647 0115* 27 Clip 9-89						** 1262	49 ps 58
NAS1149FN832P	Purchased	No	110	Each	523.0000	111 111	V
*NAS1149FN832 Washer	)P*					** 1239	00 gB 13-09-03
DAS <b>27</b>		<b>Location</b>	Loc	c Qty	Loc Code		ST
9-89		275		198			- -
		122441		198			_
		ST275 115158		125			-
		115158 ST294		125 200		- · · ·	-
		123352		200			-
							-

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE	QA Closed:	Date	۵۰.
						DISPOSITION		<u> </u>		AGAINST DE			
Work Ord	er:					DISPOSITION			AGAINST DE	EPARTMENT/PROCESS			
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
		···	1	•				L					
Root				ĺ		ption of work order update		Initial		tion	Sign &		
Cause	T .	Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data	_												
Equip/Tooling													
Operator	- 3*		]				1						
Material			•										
Setup	**				,								
Other													
Process													
Supplier					*								1
Training													
Unapproved			<u> </u>	<u> </u>			<u> </u>						
		<del> </del>			<del> </del>	F	AUI	LT CATE	GORY				
Landi	ng (	Gear			_	General	_	,					·
	-	Bending				Bend	$\perp$	Grain			Ovalized	<u>_</u>	Pressure/Forced
	L	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	_	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete	ļ	Part Incorre	ct	Weld	
	L	Crushed/	Crimped.		_	Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	led		Positioned Wrong		
	Inspection Strip in Tube			Cut Too Short		Misread	İ		Power Loss/		Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-19-12 2:44:04 PM

Work Order ID: 92038

\*92038\*

Parent Item:

646,9501

\*646 9501\*

Parent Item Name: 206 Cable Cutter, High

Start Date: 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

No

110

Each

1,274.000

123900 JB

DAS 27

Location		<u>L</u>	oc Qty	Loc Code
275			298	
	122441		298	
ST275			776	
	117735		13	
	119225		8	
	121259		138	
	121825		14	
	122063		600	
	17317		3	
ST295			200	
	123352		200	
		110	Each	346.0000

123759 99

AN3-11A Bolt

DAS	
27	
9-89	

MS21042-3

Purchased No

Purchased

Location	Lo	e Oty
ST351		346
110865		46
115457		100
123352		200
	110	Each

500.0000 17

13	-09-0	3

DAS 27 9-89

Location Loc Oty ST315 500 123352 500

Loc Code

Loc Code

123352

											DQA:	Date:	•
NCR:	Yes / No	)			WORK ORDER NON-	COI	NFOR	MANCE / UPI	DATE	Q	A Closed:	Date:	
Work Orde	or.				DISPOSITION	,			AGAINST D			/PROCESS	
Part No.  NCR No.			Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
Root				Descr	ription of work order update		Initial	Act	ion	T	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	ription		Date	Verification	QC Inspector
Doc/Data					<del>"</del>								
Equip/Tooling													
Operator				1		1							
Material			ļ										
Setup				:									
Other													
Process								1		-			
Supplier		ŀ											
Training		ļ											
Unapproved													
					<u></u>	AUI	LT CATE	GORY					
Landi	ng Gear				General		-		_	_			_
	Bendin	g			Bend		Grain			၂၀	valized		Pressure/Forced
	<b>—</b>	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		၂၀	ver/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	ion Incomplete	L	P	art Incorred	ct	Weld
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/l	Jnclear	P:	art Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		P	art Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

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Work Order ID: 92038

\*92038\*

Parent Item:

646.9501

\*646 9501\*

Location

Parent Item Name: 206 Cable Cutter, High

**Start Date:** 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

CCR264SS-3-06

Purchased

No

110

100.0000

RIVET

MS21059L08

DAS 27

9-89

Purchased No ST327 123023

100 100 110 Each

Loc Qty

Each

Loc Code

Loc Code

1,282,000 124093 98

Nut

<b>Location</b>	<u>L</u>	oc Qty
ST300		7
112314		7
ST314		400
123265		400
ST316		875
123100		775
123352		100
	110	Each

CR3213-4-05

DAS 27 9-89

Purchased No 738.0000

Loc Code

cherry rivet

DAS 27 9-89

	<u>Location</u>	Loc Oty
	ST328	600
	123301	600
	ST331	138
	108473	38
	108991	100
1		

123301

		3	•	
DQA:	Date:			

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

								,		QA Closed:	Date	<b>:</b>
Work Orde	r·				DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update	<u> </u>		Large Fab	Composite	_ Kec/stoi	Supplier	Other
Root				Descri	ption of work order update	Init	ial	Ad	ction	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief	Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											""	
Equip/Tooling Operator												
Material												
Setup												
Other						İ						İ
Process												
Supplier												
Training											1	
Unapproved						1						
					F/	AULT (	CATE	GORY				
Landin	g Gear	•			General							
	Bending				Bend	Gr	ain			Ovalized		Pressure/Forced
[	Centre No	ot Concer	ntric to C	D/S	BOM/Route	На	ırdwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	specti	on Incomplete		Part Incorre	ct	Weld
	Crushed/0	Crimped.			Burrs	Ins	struct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	М	ainte	nance		Part Moved		
	Heat Trea	t			Countersink	Шмі	islabe	led		Positioned V	Vrong _	_
	Inspection	n Strip in	Tube		Cut Too Short	Шмі	isread	I		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	Of	fset					
	Torque W	aves in E	xtrusion	· [_	Drawing	Or	it of (	Calibration				
[	Turning S	equence			Finish	Or	it of S	Sequence				
Γ	Wave/Tw	ist in Tub	e		Folio	Οι	ıtside	Dimensions				

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October-19-12 2:44:04 PM

Work Order ID: 92038

\*92038\*

Parent Item:

646,9501

\*646 9501\*

Parent Item Name: 206 Cable Cutter, High

Start Date: 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

CR3213-4-6	Purchased	No	110 Each 400.0000 20 20
*CP3943-4-6*			** 1 × m/26320 - 10
rivet			

CR3213-4-4

9-89

Purchased No

Location Loc Qty ST329 400 123301 400

110

Each

Loc Code

410.0000

Loc Code

Loc Code

Location Loc Oty ST328 400 123301 400 ST331 10 104291 10 110 Each 19x123785 20

DAS 27 CR3213-4-2

No Purchased

1,019.000 \*\*

DAS

27

9-89

Location Loc Qty ST328 1000 123301 1000 ST331 19 113288 19

123301

									DQA:	Date:	•
NCR: \	res / No				WORK ORDER NON-C	ONFORI	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	or.				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Part N NÇR N	lo				Rework Scrap Use-as-is Work Order Update	1	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering  Quality  Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	·			,							
Equip/Tooling											
Operator [											
Material [											
Setup											
Other [											
Process										÷.	
Supplier											٠.

Positioned Wrong Countersink Mislabeled Heat Treat Power Loss/Surge Other Inspection Strip in Tube Misread Cut Too Short Ripples in Bend Drill Holes Offset Drawing Out of Calibration Torque Waves in Extrusion Out of Sequence Turning Sequence Finish Folio Outside Dimensions Wave/Twist in Tube

**FAULT CATEGORY** 

Grain

Hardware

Maintenance

Inspection Incomplete

Instructions Incomplete/Unclear

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Over/Under tolerance

Training Unapproved

**Landing Gear** 

Bending

Cracks

Cuffs

Crushed/Crimped.

Centre Not Concentric to O/S

 $\sim \angle$ 

General

Bend

Burrs

BOM/Route

Contamination

Broken/Damaged

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Work Order ID: 92038

\*92038\*

Parent Item:

646.9501

\*646 9501\*

Parent Item Name: 206 Cable Cutter, High

**Start Date:** 19/10/2012

Required Date: 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

CR3213-4-3

No

110

Each

1,050.000

Loc Code

126320 18

DAS 27 9-89

MS21047-3

Purchased

Purchased

No

Location Loc Qty ST328 1000 123301 1000 ST331 50 116583 118503 120910 10 121243 30 110 Each

125.0000

Loc Code

**NUT PLATE** 

DAS 27 9-89

MS21042-08

Purchased

No

Location Loc Qty ST316 125 123268 50 123301 50 123352 25 110 Each

142,0000

DAS 27 9-89

Location Loc Qty ST300 42 103668 42 ST316 100 123352 100 Loc Code

												DQA:	Da	te:	•
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	/ANCE / UPI	DATE	(	QA Closed:	Da	te:	
Work Orde	er:					DISPOSITION				AGAINST DE		· · · · · · · · · · · · · · · · · · ·	PROCESS		
Part N NCR N	- No					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root	Ī				Doscri	tion of work order update	T	Initial	Act	tion	Т	Sign &			
		Data	Cton	Otv		or Non-conformance		nief Eng		ription	l	Date	Verificatio	n :	QC Inspector
Cause	-	Date	Step	Qty	(	or Non-conformance	Cr	iler Eng	Descr	приоп	+	Date	verilicatio		QC Inspector
Doc/Data	$\dashv$										١				
Equip/Tooling	$\vdash$			:											
Operator											Į				
Material	_										١		£ 11 _ 11		
Setup						•					١				·
Other											1				
Process "	$\dashv$				·		1				١				
Supplier	$\dashv$														
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				· · · · · · · · · · · · · · · · · · ·			AUI	LT CATE	GORY		_		-, -, -, -, -, -, -, -, -, -, -, -, -, -	,	<u> </u>
Landii	$\overline{}$				<u> </u>	General	_	Ja .			7			_	1- /- '
	-	Bending				Bend	<u> </u>	Grain		ļ	-1	Ovalized		-	Pressure/Forced
	_	Centre No	t Concer	itric to	O/S	BOM/Route	<u> </u>	Hardwa		ļ	ᅥ	Over/Under		<u> </u>	Temperature/Cure
		Cracks				Broken/Damaged	$\perp$	<b>⊣</b> `	on Incomplete		-	Part Incorred		<u>_</u>	Weld
	-	Crùshed/0	Crimped.			Burrs	$\vdash$	-	ions Incomplete/l	Jnclear	-1	Part Lost/Mi	ssing	$ldsymbol{ld}}}}}}$	Wrong Stock Pulled
	-	Cuffs				Contamination	$\perp$	Mainte		<u></u>	⊣	Part Moved			
		Heat Trea	t			Countersink	L	Mislabe	led		╝	Positioned V	Vrong		1
		Inspection	Strip in	Tube		Cut Too Short		Misread				Power Loss/	Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend



Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

October-19-12 2:44:04 PM

Work Order ID: 92038

Parent Item:

646.9501

Parent Item Name: 206 Cable Cutter, High

\*92038\*

\*646 9501\*

**Start Date:** 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

\*\*

Required Oty: 1.00

MS27039-08-13 Purchased

Screw

DAS 27 9-89

MS21059-3

Purchased

No

No

Location

4067 ST307

Location

ST316

Mezz

123352

300 110 Each

Loc Qty

250

50

200

Each

Loc Qty

92

92

300

Each

110

\*\*

392.0000

Loc Code

250.0000

23352

DAS 27 9-89

AN743-13

Purchased No

123023 123301 110 Loc Code

20.0000

123301

\*\*

13-08-28

DAS 27

9-89

Location Loc Qty ST324 121825 8 ST347 10 123352 10 ST348 2 120242 2

Loc Code

NCR:	res / No				WORK ORDER NON-	CONF	ORN	MANCE / UPDATE				
										QA Closed:	Date:	········
Work Orde	er:				DISPOSITION			AGA	INST DE	PARTMENT	PROCESS	
Part N	No				Rework Scrap		ľ	Skid-tube Cross  Machining Small	l Fab	ł	Water Jet d. Eng. Coor.	Engineering Quality
NCR <sub>_</sub> N	No			<del></del>	Use-as-is Work Order Update	]   T		noforming Finis Large Fab Compo	hing osite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initi	al	Action		Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
Doc/Data												•
Equip/Tooling												
Operator												
Material					•					1 共享		
Setup	*											
Other	_											
Process												
Supplier	_											
Training	-					}						
Unapproved		1		<del></del>		AULT C	A T C (	CORV		<u> </u>		
Landie	ng Gear				General	AULIC	AIE	JUNY			+ G <sub>1</sub> <sup>3</sup> - g <sub>1</sub> + g <sup>2</sup> + c s = g	
Lanun	Bending				Bend	∏Gra	ain			Ovalized		Pressure/Forced
	Centre No	nt Concer	ntric to O	1/5	BOM/Route	$\vdash$	rdwa	ro	$\vdash$	Over/Under	tolerance	Temperature/Cure
	Cracks	or concer	itric to o	″³   <del>-</del>	Broken/Damaged	$\vdash$		on Incomplete	-	Part Incorre	<del> </del>	Weld
l	Crushed/	Crimned		-	Burrs	<b>-</b>	-	ions Incomplete/Unclear	-	Part Lost/Mi	<del>-</del>	Wrong Stock Pulled
	Cuffs	cimped:			Contamination	$\vdash$		nance	-	Part Moved		
	Heat Trea	ıt			Countersink	$\vdash$	slabe		-	Positioned V	Vrong	
	Inspection		Tube		Cut Too Short	<b></b>	sread			Power Loss/		Other
	Ripples in				Drill Holes	Off				,		<u>,,,,,</u>
	Torque W		xtrusion		Drawing	_		Calibration				
	Turning S				Finish	Ou	t of S	equence				

Outside Dimensions

\_Date: \_\_\_\_\_

DQA:

Wave/Twist in Tube

Work Order ID: 92038

646,9501

Parent Item Name: 206 Cable Cutter. High

Parent Item:

CCR264SS3-04

\*92038\*

\*646 9501\*

Start Date: 19/10/2012

**Required Date:** 02/11/2012

Start Qty: 1.00

Required Qty: 1.00

125709 JB

AN3-3A

DAS 27 9-89

Purchased

Purchased

No

No

No

Location Loc Qty ST350 355

110

122416 55 122800 200 123352 100

110

Each

Each

Loc Code

355,0000

646,0000

\*\*

DAS 27

9-89

CR3212-5-4 Purchased

Location Loc Qty ST327 200 123352 200 ST331 446 17997 446 110 Each

368.0000

Loc Code

\*\*

13-08-28

Cherry Rivet

DAS 27 9-89 Location Loc Qty ST328 200 123301 200 ST330 168 120308 68 120410 100

Loc Code

20308

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	AANCE / UPI	DATE	0.4.61	D-1-	
			****								QA Closed:	Date	
Work Ord	er:		•			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part						Rework Scrap Use-as-is		ſ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.					Work Order Update	j		Large Fab	Composite	J	Supplier	
Root					Descri	otion of work order update	T	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Cł	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data	L												
Equip/Tooling													
Operator							ļ						
Material		1											
Setup												n 2	
Other							1						İ
Process		ĺ											
Supplier													
Training													
Unapproved	一												
,,,	1		1	<u></u>	4		AUI	T CATE	GORY				
Landi	ing (	Gear				General		********					
		Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre		Weld
		Crushed/	Crimped			Burrs		-1	ions Incomplete/l	Unclear	Part Lost/M	<b>-</b>	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	•		Part Moved		<b>J</b> ~
		Heat Trea	it		<u> </u>	Countersink		Mislabe			Positioned \		
	$\vdash$	Inspection		Tube		Cut Too Short		Misread			Power Loss/	_	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 92038 \*92038\* Parent Item: 646.9501 \*646 9501\* Parent Item Name: 206 Cable Cutter, High Start Date: 19/10/2012 **Required Date:** 02/11/2012 Start Qty: 1.00 Required Qty: 1.00 CCR264SS3-2 No Purchased 110 154.0000 Each \*\* 124876 JB DAS Location Loc Oty Loc Code 27 ST331 154 9-89 106578 104 108738 2 112314 48 NAS1835-08 Purchased No 110 Each 50.0000 \*\* Location Loc Oty Loc Code ST298 50 DAS 123055 27 123055 40 g-89 123078 10 CR3213-4-1 Purchased No 110 Each 400.0000 13-08-28 Location Loc Oty Loc Code ST328 400 12330 123301 400

DAS 27 9-89

											DQA:	Date:	*
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPI	DATE	QA Closed:	Date:	
						· .		<u> </u>			QA Closed:	Date	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	- _ No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	i	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
·	7					Work Order opdate			raige rab	Composite	J	Supplie [_	ــا
Root			:		Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator			1										
Material	Ц						1						
Setup													-
Other	Ш											]	
Process	Ш												
Supplier	Ш						l	i					
Training	Ш												
Unapproved					·	<u> </u>	<u> </u>						
						<del></del>	AUL	T CATE	GORY				1
Landi	$\overline{}$	ear 💈				General		7			7		<b>-</b>
	-	Bending				Bend	$oxed{}$	Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	BOM/Route	<u> </u>	Hardwa	re		Over/Under	tolerance	Temperature/Cure
<b>]</b> .	Ш	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.		ļ	Burrs	<u></u>	4	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte		<u></u>	Part Moved		
		Heat Trea	t			Countersink		Mislabe	led		Positioned \	_	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss,	'Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

October-19-12 2:44:04 PM

Work Order ID: 92038

\*92038\*

Parent Item:

646,9501

\*646 9501\*

Parent Item Name: 206 Cable Cutter, High

Start Date: 19/10/2012

**Required Date: 02/11/2012** 

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

110

Each 1,196.000

\*\*

125-654 13

CAG

647.1210

-
3
S
S

No

Manufactured No Location Loc Oty Loc Code 308 168 122452 168 ST291 672 117423 71 119075 120308 121011 43 121243 500 121708 13 ST305 356 123265 356 110 Each 18.0000

\*\*

DAS 27 MS35842-11

Purchased No

Location Loc Qty Loc Code ST438 18 91438 18 110 Each 8.0000

91438 \*\*

Loc Code

13-08-28

DAS 27 9-89 Location Loc Oty ST290A 8 123023

123023

NCR: '	Yes / 1	lo			WORK ORDER NON-	CON	NFOR	MANCE / UP	DATE	QA Closed:	Date	
-					DISPOSITION				AGAINST DE		***************************************	
Work Orde	er:					٦l		<del></del>		rani ivicivi,		-1 <u></u> 3
					Rework	4		Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	No				Scrap	-		Machining	Small Fab	4	d. Eng. Coor.	Quality Other
NCR i	No				Use-as-is Work Order Update	]	inem	noforming Large Fab	Finishing Composite	, Rec/Stor	e/Packaging Supplier	- Other
Root				Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause	Da	e Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		İ										
Equip/Tooling			ŀ									
Operator			ŀ									
Material			İ									
Setup												^
Other	Ш								•			
Process		į									•	
Supplier												1
Training	Ш											
Unapproved					· · · · · · · · · · · · · · · · · · ·							
						AUL	T CATE	GORY				
Landi	ng Gear				General		i			: ; ·		· -
	Bend	•			Bend		Grain			Ovalized		Pressure/Forced
	Centr	e Not Conce	ntric to	o/s	BOM/Route	$\vdash$	Hardwa			Over/Under	tolerance	Temperature/Cure
	Crack				Broken/Damaged	_		ion Incomplete	_	Part Incorre	<del> </del>	Weld
	⊢	ed/Crimped	l.		Burrs			ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			ļ	Contamination		Mainte			Part Moved	Mark Harris	,
	Heat	Treat		<u> </u>	Countersink		Mislabe	led		┥		in the state of th
į	Inspe	ction Strip ir	1 Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
	Ripple	es in Bend			Drill Holes		Offset				***************************************	<u>N</u>
	Torai	e Waves in	Extrusio	n İ	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Date: "

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

Work Order ID: 92038 \*92038\* Parent Item: 646.9501 \*646 9501\* Parent Item Name: 206 Cable Cutter, High Start Date: 19/10/2012 **Required Date:** 02/11/2012 Start Qty: 1.00 Required Qty: 1.00 MS27039-08-11 Purchased No 110 Each 646.0000 \*\* 125654 28 Location Loc Oty Loc Code DAS 309 100 27 122441 100 ST292 46 120833 46 ST307 500 123352 500 MS27039-08-06 Purchased No 110 Each 100.0000 λS Location Loc Qty Loc Code ST293 100 117065 100 MS27039-08-09 Purchased No 110 Each 51.0000 Location Loc Qty Loc Code BAG Mezz 51 27 11187 51 MS27039-08-12 Purchased No 110 131.0000 Each \*\* 123900 JB

DAS 27 9-89 
 Location
 Loc Oty
 Loc Code

 Mezz
 31

 1850
 31

 ST307
 100

 123352
 100

October-19-12 2:44:04 PM

Shop Packet Print

Page 11

NCR: \	res / No				WORK ORDER NON-	CON	FORN	MANCE / UP	DATE	•		
										QA Closed:	Date:	
Work Orde	er:				DISPOSITION	-			AGAINST DE	PARTMENT	/PROCESS	,
Part N	 Jo				Rework Scrap	]		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCŖ N					Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite		re/Packaging Supplier	Other
Root				Descri	ption of work order update	In	itial	Act	tion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling									•			
Operator												
Material												
Setup			1 1									
Other [												]
Process	٠, ــــ				·							
Supplier												
Training												
Unapproved												
					· · · · · · · · · · · · · · · · · · ·	AULT	CATE	GORY	, 			·
Landir	ng Gear				General			•		•		-
	Bending				Bend	$\vdash$	Grain			Ovalized		Pressure/Forced
	Centre N	ot Concer	ntric to O	/s	BOM/Route	⊢∟⊦	lardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			· L	Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
<u> </u>	Crushed/	Crimped.			Burrs	l'	nstruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		√lainte	nance	<u></u>	Part Moved	: .:	
	Heat Tre	at			Countersink		∕Iislabe	led		Positioned \	Vrong	<b>-</b>
	Inspection	n Strip in	Tube		Cut Too Short	<u></u>	∕isreac	I		Power Loss/	Surge	Other
[	Ripples ii	n Bend			Drill Holes		Offset					
[	Torque V	Vaves in E	xtrusion		Drawing		Out of C	Calibration				
[	Turning S	Sequence			Finish		Out of S	equence				
	Wave/Tv	vist in Tub	oe -		Folio		Outside	Dimensions				

Date: \_\_\_\_

DQA:

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October-19-12 2:44:04 PM Work Order ID: 92038 \*92038\* Parent Item: 646.9501 \*646 9501\* Parent Item Name: 206 Cable Cutter, High **Start Date:** 19/10/2012 **Required Date:** 02/11/2012 Start Qty: 1.00 Required Qty: 1.00 MS27039-1-11 No 110 Purchased 137.0000 Each \*MS27039-1-11\*) Location Loc Qty Loc Code DAS Mezz 37 9662 37 ST305 100 123352 100 CR3212-4-4 Purchased No 110 Each 200.0000 \*\* - Cherry Rivet Location Loc Qty Loc Code ST328 200 123346 200 MS24694-S8<sup>3</sup>-89 Purchased No 110 Each \*MS24694-S8\* Screw Location Loc Oty Loc Code ST302 200 DAS 123 348 123348 100 27 123352 100 AN3-10A Purchased No 110 Each 251.0000 78 125709 JB Bolt Location Loc Qty Loc Code CAG ST351 251 120873 17 122800 234 647.5701 Manufactured 110 Each 0.0000

\*647 5701\*

GPS Mount

October-19-1272:44:04 PM

W. 13-0-08

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Page 12

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPI	DATE	QA Closed:	 Date:	
							DISPOSITION			<u> </u>	ACAINST DE			
Nork Ord	er:						DISPOSITION				AGAINST DE	PAKIIVIENI	PROCESS	
Part NCR						•	Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
						•	<u> </u>							
Root					Des	scri	otion of work order update	1	nitial	Act	tion	Sign &		
Cause	,	Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining					,									
			· · · · · · · · · · · · · · · · · · ·				F	AUL	T CATE	GORY				
Landi	ng (	Gear					General		_			_	·	
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t n Strip in Bend	Tube			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/l nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning So	equence				Finish	1	Out of 9	equence				J

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Work Order ID: 92038		*92038*			
<b>Parent Item:</b> 646.9501		*646 9501*			
Parent Item Name: 206 Cable Cutter	()() ()()()			<b>Start Date:</b> 19/10/2012 <b>Required Date:</b> 02/11/2012	
					Start Qty: 1.00 Required Qty: 1.00
*600.0990 *600.0990 *21 Magnabond 6398 Part A (One 4 of Can)	Purchased	No	110	Each	0.0000 ** 126215 JB SP
*600.0991 *600-0994.*)	Purchased	No	110	Each	0.0000
Magnabond 6398 Part-B (One 4 oz can) 600.1012  *600.1012  *600.1012  *27 9-89  Sealant (One 6 oz Semkit)	Purchased	No	110	Each	0.0000 ** 12-08-28

DAS 27 9-89

												DQA:	Date:	•
NCR: Yes / No							WORK ORDER NON-CONFORMANCE / UPDATE						Date	·
Work Order: DISPOSITION														
Part No							Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite		Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root	· · · · · · · · · · · · · · · · · · ·		-	iption of work order update		Initial	Action		Sign &					
Cause	Γ	Date	Step	Qty		or Non-conformance		Ch	nief Eng Description		ription	Date	Verification	QC Inspector
oc/Data	<u> </u>													
quip/Tooling	-													
perator														
Material	· · · ·													
etup )ther	_													
rocess														
upplier														
raining										·				
inapproved														
			1	11			F	AUL	T CATE	GORY			L	
Landi	ng (	Gear					General							
		Bending			В	end		Grain Hardware			Ovalized Over/Under tolerance		Pressure/Forced	
		Centre No	Centre Not Concentric to O/S			Πв	BOM/Route						Temperature/Cure	
		Cracks			В	Broken/Damaged Burrs		Inspection Incomplete Instructions Incomplete/Unclear			Part Incorrect Part Lost/Missing		Weld	
		Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube											В	Wrong Stock Pulled
						c	ontamination		Maintenance			Part Moved		
						c	Countersink Cut Too Short Drill Holes Drawing		Mislabeled Misread Offset Out of Calibration Out of Sequence			Positioned Wrong Power Loss/Surge Other		
						c								
		Ripples in Bend Torque Waves in Extrusion			_]p									
					D									
	Turning Sequence Wave/Twist in Tube				Fi	nish								
					F	olio	Outside	Dimensions						

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# \*92038\*

October-19-12 2:43:59 PM Accept 646.9501 Item ID: **Revision ID:** Item Name: 206 Cable Cutter. High Start Qty: 1.00 **Start Date:** 19/10/2012 **Required Date:** 02/11/2012 Req'd Qty: 1.00 Reference: Date: 12-10-19 Tooling: **Approvals: Process Plan:** MUJ SPC (Y/N): QC: Date: Operation Set Up/ Sequence ID/ Description **Run Hours** Work Center ID **Revision Nbr Draw Nbr** N/C 646,9500 0.00 100 DOCUMENT CONTROL \*100\* 0.00 DC Memo Photocopy bluefile & type labels per PPP 646.9501 Document Control 0.00 Pick Kit 110 \*110\* 0.00 Packaging Memo Packaging 0.00 QC4-100% Inspect kits for completeness 120 \*120\* 0.00 QC Memo Quality Control

Work Order ID 92038

Customer:

Run Start \*NR1

Date:

Setup Start

\*N900040100\*

Date:

Cust Item ID:

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

85.80-81 WM